

Shy Andy 10/01

Rev A 5/16/12

Work Order ID 111121

111121

Page 1

January-09-14 10:13:25 AM

Item ID: D5023-3
Revision ID: PRELIM
Item Name: Cover Plate

Accept

N1900040100

Setup Start

NS1

Stop

NS2

Start Date: 1/09/14 Start Qty: 6.00 *6*
Required Date: 1/09/14 Req'd Qty: 6.00 *6*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D5023	ATT <u>Rev A</u>								

DAS
10
9-89

110 0.00

110

Waterjet

FLOW CNC Waterjet

6061.080"

Memo

1-Cut D5023-3 as per Dwg

Dwg Rev: A11

Prog Rev: A11

2-Deburr if necessary

120 0.00

120

QC

Quality Control

Memo

QC2- Inspect parts off machine FAI/FAIB

0.00

6 0 Jm 14-1-9

6 0 Jm 14-1-9

Work Order ID 111121

111121

Page 2

January-09-14 10:13:25 AM

Item ID: D5023-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Cover Plate
 Start Date: 1/09/14 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 1/09/14 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									DAS
QC	Memo	0.00				6	14-01-09		9-89
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00				6	7/6 14-1-9		
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									DAS
QC	Memo	0.00							27
Quality Control									9-89

14/1/9

6

Inspected on
Res Due All

Work Order ID 111121

111121

Page 3

January-09-14 10:13:25 AM

Item ID: D5023-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Cover Plate
 Start Date: 1/09/14 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 1/09/14 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per OSI005 4.3	0.00							
160	<i>M126878.</i>					6	0	14-1-10.	DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>10:20</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>12:00</i>								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging									

POSITIVE RECALL
 AUTH *✓*
 DATE *14/4/22*
 Release Dwg
 as per Rev

Work Order ID 111121

111121

Page 4

January-09-14 10:13:25 AM

Item ID: D5023-3

Revision ID: PRELIM

Item Name: Cover Plate

Start Date: 1/09/14 Start Qty: 6.00

Required Date: 1/09/14 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

14-01-23

MF

14-01-13

Picklist Print

January-09-14 10:13:25 AM

Page 1

Work Order ID: 111121

Parent Item: D5023-3

Parent Item Name: Cover Plate

Start Date: 1/09/14

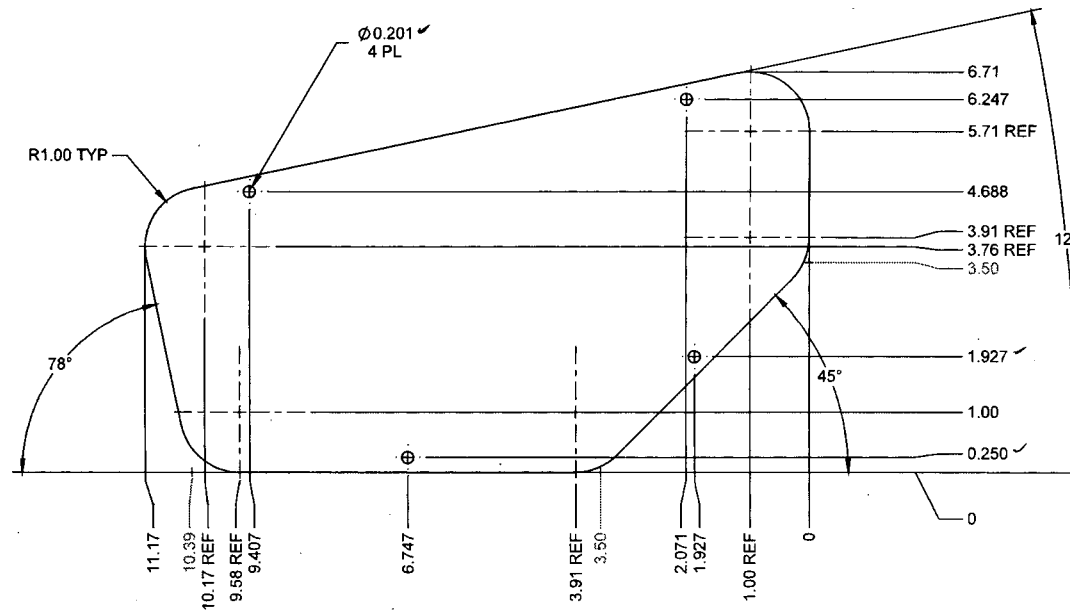
Required Date: 1/09/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.12.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	326.7600		④			Jm14-1-9
6061-T6 .080 Sheet													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MAT021			326.76						
				m126309			305						
				m126350			21.76						
										126350			



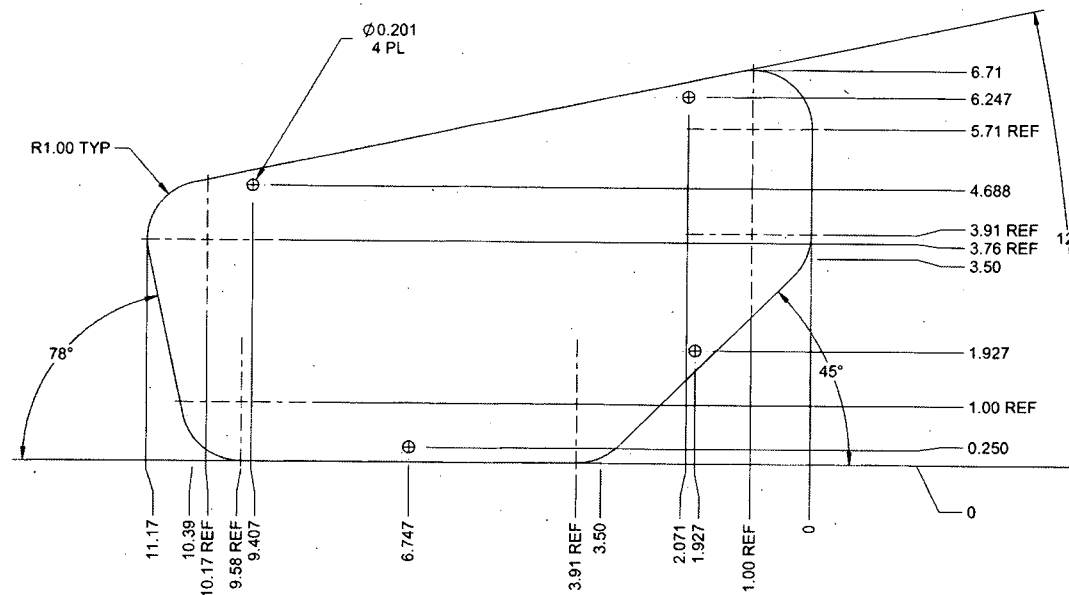
D5023-3 COVER PLATE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5023-3_REVA.DXF".

PRELIMINARY ISSUE

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. A11
MFG. APPR.	DD	D5023	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL	NTS
DATE	13.12.12	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D5023-3 COVER PLATE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
(REF: DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5023-3_REVA.DXF".

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. A
MFG. APPR.	DD	D5023	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	INSTRUMENT PANEL	NTS
DATE	13.12.12	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	